

Work Order ID 92990

November-13-12 9:51:35 AM

92990

Page 1

Item ID: D3875-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Protector

Start Date: 13/11/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 27/11/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-11-13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3875	Rev A								
100		0.00							
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								
105		0.00							
105									
HandThermo	Dry Material	0.00							
Hand Finishing Thermoforming	Memo								
	Dry Sheet as per QSI022 POLYCARBONATE								
	Temp: <u>240° F</u>								
	Time IN: <u>7:00 am</u>								
	Time OUT: <u>7:00 am</u>								

DAS
07
289
12/11/13

DAS
07
289
12/11/13

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Page 2

Item ID: D3875-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Protector

Start Date: 13/11/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 27/11/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

110

0.00

110

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9435
Dwg Rev: A
Folio Rev: B

Visually inspect for proper formation and texture

x2

DAS
12/11/13

140

0.00

140

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x2

B 12/11/15

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.00

Quality Control

Complete FAI document

x2

B 12/11/15

92990

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 13/11/2012 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 27/11/2012 **Req'd Qty:** 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:**

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Insp. Stamp

0.00

160

QC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

Picklist Print

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Page 1

Work Order ID: 92990

Parent Item: D3875-1

Parent Item Name: Floor Protector

92990

D3875-1

Start Date: 13/11/2012

Required Date: 27/11/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	821.7749	9.84	19.68			

MI FXS 118-90318-08

Lexan Sheet

**

Location

therm

Loc Qty

821.7749406

821.774941

Loc Code

113127

19.68 sq ft.

DAS
07
12/11/15

DART AEROSPACE LTD		Work Order:	92990
Description: Floor Protector		Part Number:	D3875-1
Inspection Dwg: D3875 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

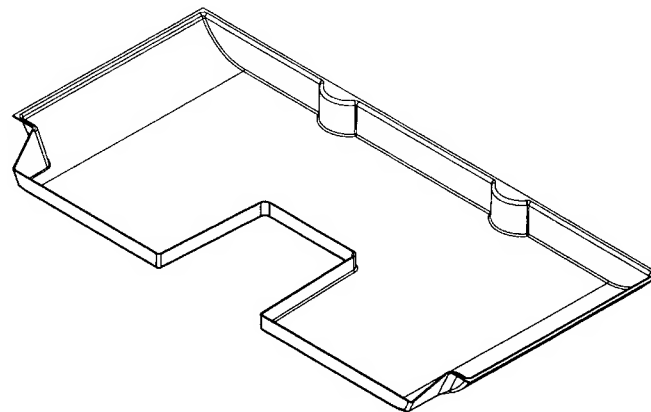
Measured by: BB Date: 12/11/15

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.081	✓		DL-01	
0.080	Min	0.085	✓		TH-DT	
45.2	+/-0.100	45.3	✓		DL-02	
21.8	+/-0.100	21.75	✓		DL-02	
1.4	+/-0.100	1.432	✓			

Measured by: BB Date: 12/11/15
Audited by: DA Date: 12/11/15
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	



D3875-1 FLOOR PROTECTOR (206B)

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO CANCELLMENT
 WITHOUT NOTICE
 WORK ORDER

92990 MLJ

12-11-13

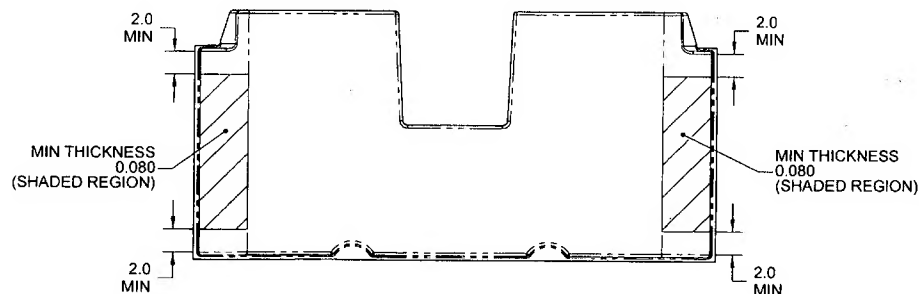
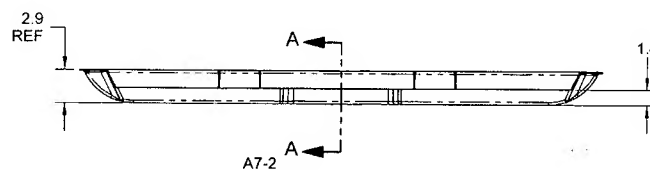
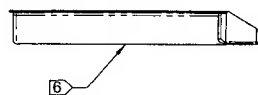
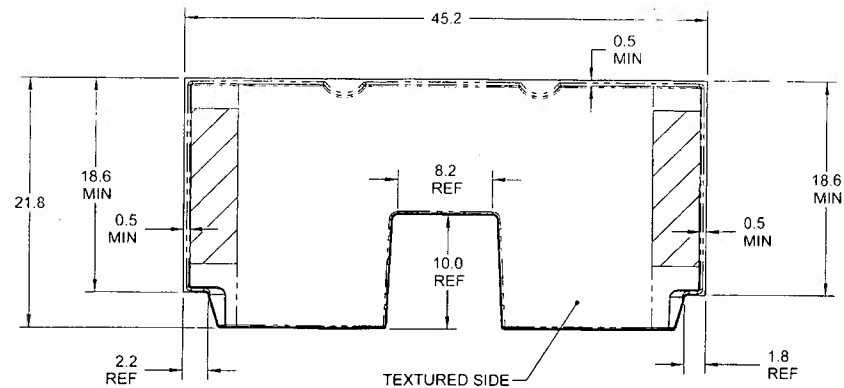
RELEASED
 29/05/05 NPB

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3875-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9475 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A	NEW ISSUE		PH	09.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AK			
CHECKED	LS	DRAWING NO.	REV. A	
MFG. APPR.	TS	D3875	SHEET 1 OF 2	
APPROVED	AK	TITLE	SCALE	
DE APPR.	AK	FLOOR PROTECTOR (206B)	NTS	
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SECTION A-A B4-2

D3875-1 FLOOR PROTECTOR (206B)

RELEASED
09/05/05

DESIGN	REF	DART AEROSPACE LTD	
DRAWN	REF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	REF	DRAWING NO.	REV. A
MFG. APPR.	REF	D3875	SHEET 2 OF 2
APPROVED	REF	TITLE	SCALE
DE APPR.	REF	FLOOR PROTECTOR (206B)	NTS
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